

Date: Monday, 6/12/2006 3:37:54 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 27519		
Estimate Number	: 12337		
P.O. Number	: NIA	Part Number	: D3492043
This Issue	: 6/12/2006 S.O. No. : NIA	Drawing Number	: D3492 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 26305	Material	: NIA
Written By	: <u>SAK COMMENT BELOW</u>	Due Date	: 7/5/2006
Checked & Approved By	: <u>06.06.13 W</u>	Qty:	60 Um: Each
Comment	: Est Rev: A 06.03.21 New Issue JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R0625	6061-T6 Round Bar .625"
-----	--------------	-------------------------



Comment: Qty.: 0.0656 f(s)/Unit Total: 3.9375 f(s)  
 6061-T6 Round Bar .625"  
 (M6061T6R625)  
 Batch: B18740

BC 06.06.22

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA632 & Dwg D3492  
 Dwg Rev: A  
 Folio Rev: AA

BC 06.06.22 63

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 06.06.22 63

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 06.06.22 63

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr

ml 06/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 26/08/13

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/12/2006 3:37:54 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 27519

Part Number: D3492043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1.

HM 06-06-27

(63)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

DL 06/08/14

(63)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06-08-15

(63)

9.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-013 O-RING

M101396 X 44  
M101519 X 19

DL 06/08/15

(63)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube  
A/R 55-O'Ring Lube Batch: M101223

DL 06/08/15

(63)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 06 08 15

(63)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FP 15

DL 06/08/15

(63)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/08/15

(63)

DL 06/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

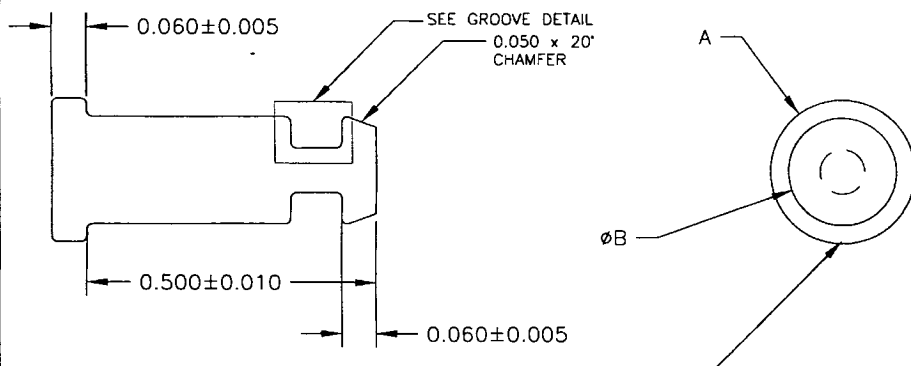
W/O: .		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

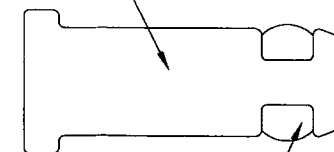
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



D3492-1/-3/-5 PLUGS IN ACCORDANCE WITH TABLE 1

D3492-1/-3/-5 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-003/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

**D3492-041/-043/-045 PLUG ASSEMBLY**

**D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST**  
(TABLE 2)

Qty -041	Qty -043	Qty -045	Part Number	Description
X			D3492-041	PLUG ASSEMBLY
	X		D3492-043	PLUG ASSEMBLY
		X	D3492-045	PLUG ASSEMBLY
1			D3492-1	PLUG
	1		D3492-3	PLUG
		1	D3492-5	PLUG
		1	NAS1611-003	O-RING
1			NAS1611-010	O-RING
	1		NAS1611-013	O-RING

**TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.500	0.394	0.055	M6061T6R0.500
D3492-3	0.625	0.582	0.045	M6061T6R0.625
D3492-5	0.375	0.188	0.045	M6061T6R0.250

**D3492-1/-3/-5 PLUG NOTES**

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- BREAK ALL SHARP CORNERS 0.010 MAX

RELEASED  
06.01.04

A		06.01.04		NEW ISSUE	
DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO. D3492	REV. A
DATE 06.01.04				TITLE PLUG	SHEET 1 OF 1 SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

WORK ORDER  
27519  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

